

17/09

Date: Tuesday, 9/11/2007 10:56:23 AM
User: Chantal Lavoie

Process Sheet

Customer :	Drawing Name :	COVER
Job Number : 34543		
Estimate Number : 12962		
P.O. Number : N/A	Part Number :	D36413
This Issue : 9/11/2007	S.O. No. : N/A	Drawing Number : D3641 UNDER REVIEW
Prsht Rev. : NC	Project Number :	N/A
First Issue : N/A	Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : 33723	Material :	N/A
Written By : <u>JA</u>	Due Date : 9/18/2007	Qty: 12 Um: Each
Checked & Approved By : <u>JA</u>		
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 0.8244 sf(s)/Unit Total: 9.8923 sf(s)

M6061-T6 .032" THK sheet

Batch: M18375 WB 07-09-12



2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3641

Dwg Rev: A WB 07-09-12

Prog Rev: A



2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

WB 07-09-12

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07/09/12 (13)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3641

EB 07/09/13



~~See 07/09/12 for change~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.09.12	S.O	120° ANGLE NOT ACHEIVED 2.50 IS 2.67	LE 07.09.12	ACCEITABLE, PART WILL FUNCTION IN SERVICE AS INTENDED. NOT A STRUCTURAL PART	LE 07.09.12	Sc 07/11/13	LE 07.09.12 QS1042	Ep 07/11/13

NOTE: Date & initial all entries

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User: Chantal Lavoie

Process Sheet

- Customer:

Drawing Name: COVER

Job Number: 34543

Part Number: D36413

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/13 (13)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-09-14 (13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/09/14 (13) counter

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

11/01/15 SC (13x)

07/09/14
ENGINEERING
APPROVAL
ENGINEERING (13)



10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/16
11/01/16

Job Completion



POSITIVE RECALL

EFFECTIVE

07-09-13

AUTH

RELEASED

16

DATE

07-10-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

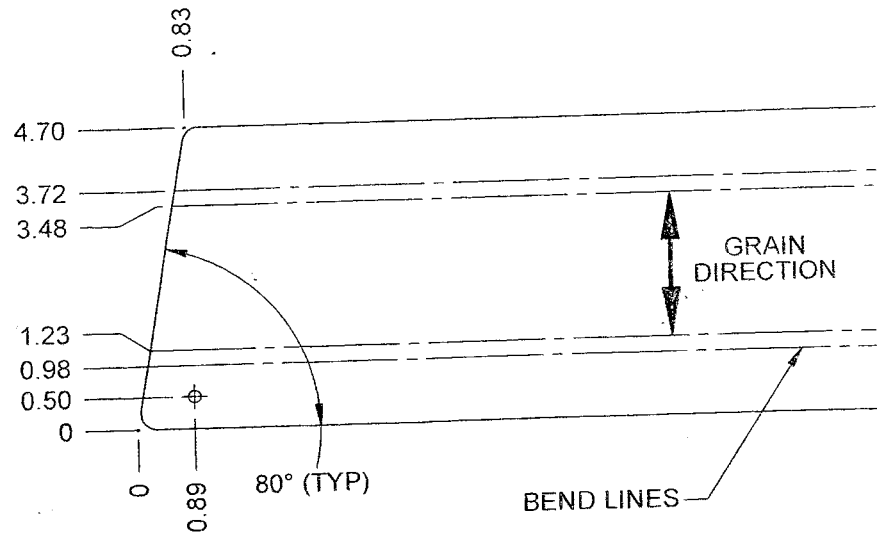
8

7

6

5

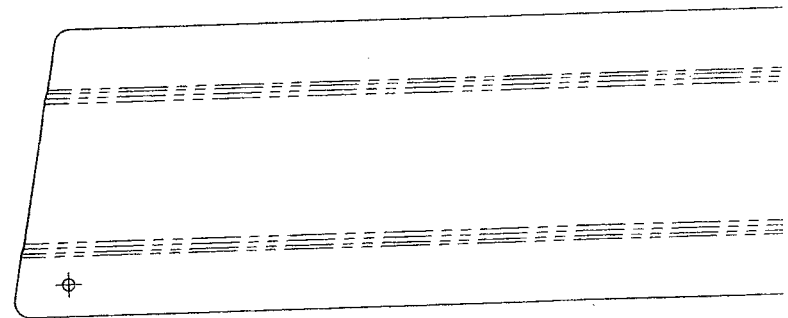
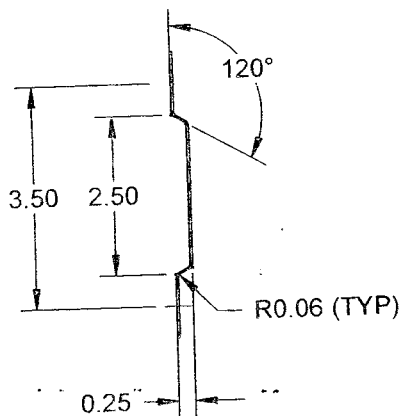
D



C

D3641-3F FLA7

B



W/634549

D3641
 (REPLACES GEI
D3641-4
 (REPLACES GEI

A

NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.032 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

7

6

5

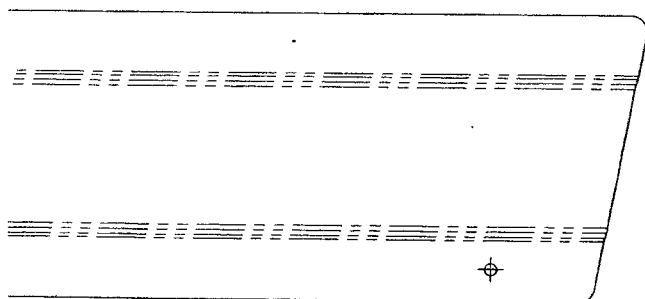
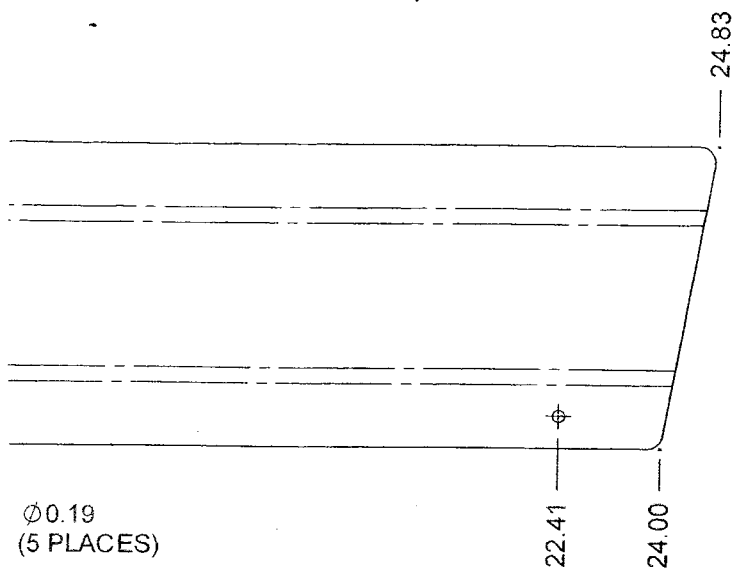
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



10606-5)

10606-4)

PRELIMINARY ISSUE

07.07.07 16

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	EE	D3641	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.		COVER	1:3
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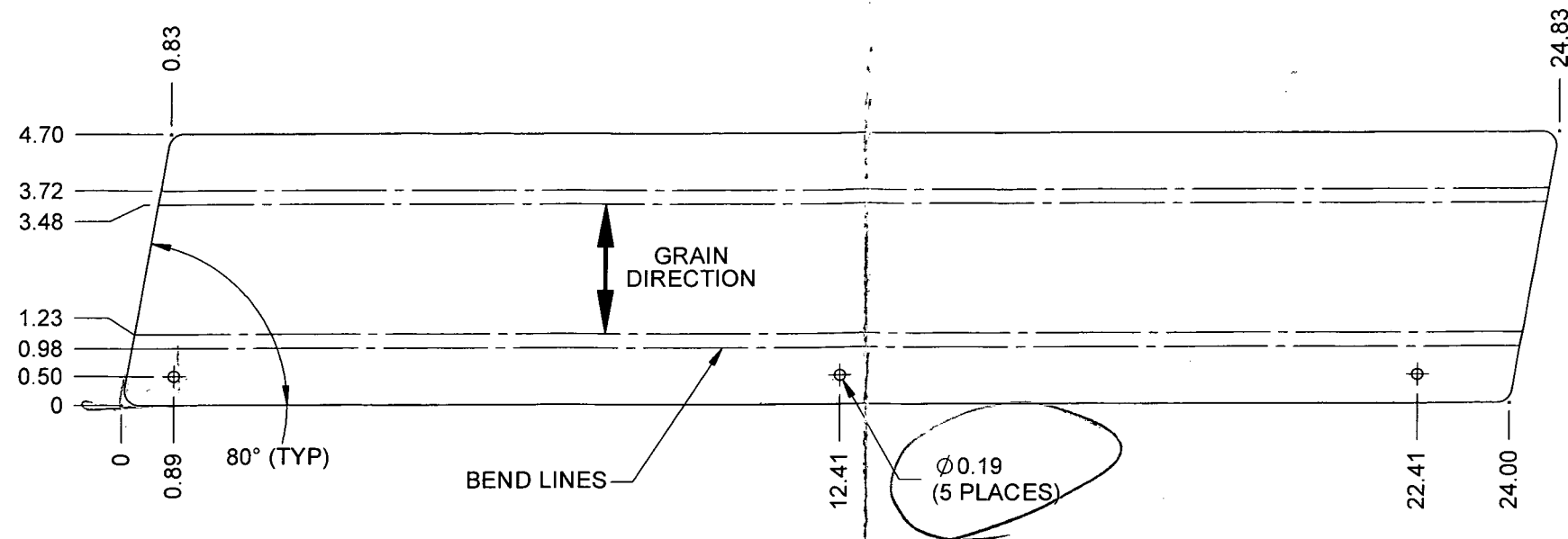
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

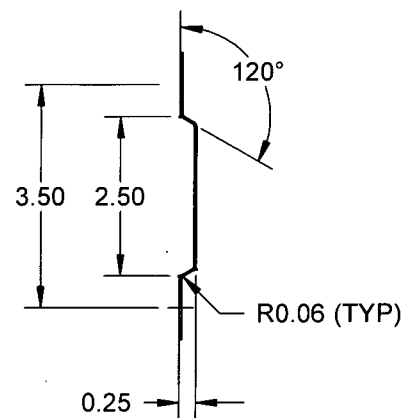
QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3641-3F FLAT PATTERN



**D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
(REPLACES GENEVA P/N G10606-4)**

PRELIMINARY ISSUE

07.09.07 *LE*
(EXTRA COPY)

NOTES:

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	E	D3641	SHEET 2 OF 2
APPROVED	140	TITLE	SCALE
DE APPR.		COVER	1:3
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Non-Conformance Report				NCR 08-112	
Raised by: <u>Jason Murdoch</u>		Source: <u>Q.C. Inspection</u>		Sheet No. <u> </u> of <u> </u>	
Non-Conforming Dept./Supplier: <u>Procl - Packaging stores</u>		Date: <u>08-11-12</u> 11-12		Priority: <u>HIGH</u> <u>LOW</u>	
Product/Service: <u>shoulder harness kit (D350-764-011) D3641-3 & -4</u>					
Area of Standard: QSI		Section A			
QSP		Description of Non-Conformance: <u>The -3 and -4 parts</u>			
QSPM		<u>were mixed up & not identified correctly. They</u>			
		<u>were stocked & identified as the opposite.</u>			
Documents:		See also w/o D350-764-011 B 43227			
P/O		REFERENCE ONLY			
Invoice					
W/O					
Batch No. <u>34543 & 34544</u>					
TSR					
Drawing <u>D3641</u>		Root Cause: <u>The drawing was not verified when identifying the parts for stock. Lack of Attention.</u>			
Forward to Director, Quality Assurance on completion of Section A					
DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.					
Section B		Responsible for Investigation/CA: <u>L. Lucelle</u> To be done by: <u>08-11-20</u>			
Corrective Action					
No	Initial	Action Description	Responsible	Due date	Sign/Date
1	J.M.	Determine affected kits & None in stock of the D350-764-011	L. Lucelle	06/11/12	J.M. 06/11/12
2	J.M.	Quarantine all stock. Note: 1x D3641-3 was found changed in w/o above.	J.M.	06/11/12	J.M. 06/11/12
3	J.M.	Re-identify stock: Qty 1 -4 B34544 → now -3 B 34543	J.M.	06/11/12	J.M. 06/11/12
4	J.M.	Ensure all Employees are aware to verify the drawing in relation to the part when identifying, and to ask questions if they are uncertain of the views on the drawing. Re-train the employees on how to interpret the drawing, and views.	J.M.	08-11-12	J.M. 08/11/18 J.M. 08/11/18 J.M. 08/11/18 J.M. 08/11/18
5	J.M.	Attach a copy of the NCR to the original copy of all the affected w/o's.	J.M.	08-11-20	J.M. 08/11/20
Preventive Action Required: <input checked="" type="radio"/> NO <input type="radio"/> YES # <u> </u>			Fault Category: <u>Procl - Stores packaging</u>		
Section C		Responsible for Verification of CA: <u>S. Sheld</u>			
Verification of C/A					
No	Verification Method		Sign	Date	
1					Forward to DQA on Completion of Verification DQA: <u> </u> Date: <u> </u>
2	Discussed w/ NCR Review				
3					
4	System in place to prevent recurrence.				
5					
QA Purposes only			N/C Closed		Date <u> </u>